

# Work Order ID 87106

\*87106\*

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July-10-12 3:18:40 PM

Item ID: 41232-200-004-001

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Reducer Tee Assembly

Start Date: 7/10/12 Start Qty: 4.00

\*4\*


Cust Item ID:

Required Date: 7/27/12 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan:  Date: 12-07-11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
41232-200-004	Rev IR								

100

0.00

\*100\*

CONVENTIONAL LATHE

Lathe Conv

Memo

0.00

Conventional Lathe

1-Turn AN815-4J as per Dwg 41232-200-0042-Debur as Required.

12-08-15

4

110

0.00

\*110\*

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1-Drill as per Dwg 41232-200-00  
2-SPOT FACE 5/8" TO LOCATE FITTING FOR WELDING  
3-Debur

12-08-15

4

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Memo

0.00

Quality Control

12-08-15

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 87106

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Item ID: 41232-200-004-001

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Reducer Tee Assembly

Start Date: 7/10/12 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 7/27/12 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140		0.00							
<b>*140*</b>	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld as per Dwg 41232-200-004 A/R	SS Rod							
	Batch: <u>M114509</u>								
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control	1-WELD INSPECTION 2-Pressure test as per Dwg 41232-200-0043- Passivate Finish.								

*tested to 3000psi* *12-08-23*  
*Pickling solution*  
*Passivating solution* *M115318*  
*12-09-13*

*DAS 13 12/8/16*

*(4) 12/8/16*  
*Pt3 ->*

*DAS 10 12-08-16*

W/O: 47106		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 41232-001-001 PAR #: 200 Fault Category: Log PAB/welding NCR: Yes No DQA: 391.45 Date: 12/09/20  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 12/9/21

NCR: 12-1812		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/08/17	#140	Q101 part drops during welding. Part suffers damage on end of Flange hole. Re. Log misshandling of part.	12/08/17 21042	- SCRAP + DESTROY no replace (Part was destroyed)	EL 12-8-17	ll 12-09-18	12/08/17 21042	DAS 16 8-83 12/08/17

NOTE: Date & initial all entries

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Item ID: 41232-200-004-001

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Reducer Tee Assembly

Start Date: 7/10/12 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 7/27/12 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>377</u>	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

3/2 Sh 10/9/17

12/9/18 JD

1120917

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 87106

Parent Item: 41232-200-004-001

Start Date: 7/10/12

Required Date: 7/27/12

Parent Item Name: Reducer Tee Assembly

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-03-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN815-4J union		Purchased	No			100	Each	8.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST324		8							
				104253		4							
				115101		4							
AS1035J080812 TEE		Purchased	No			100	Each	6.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST283		6							
				115055		6							

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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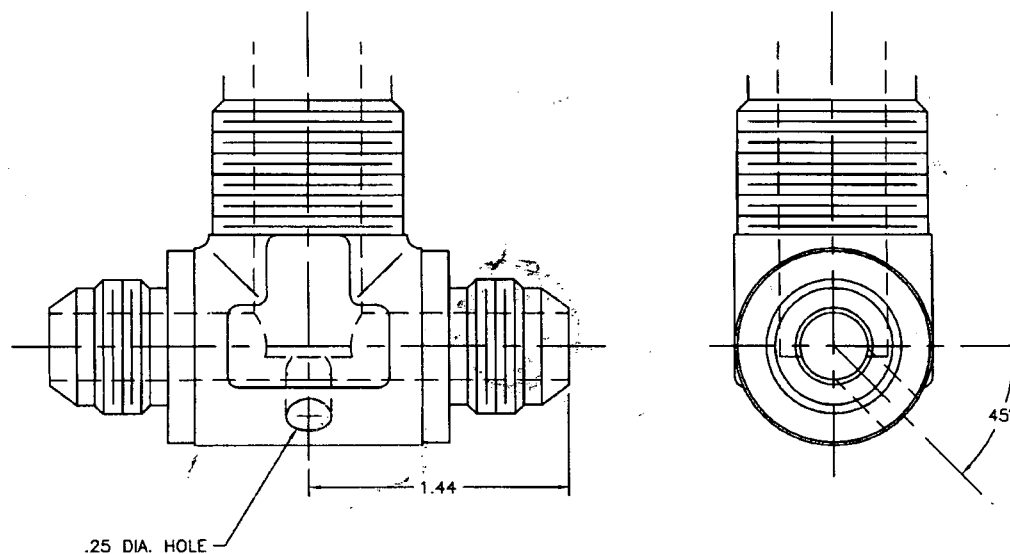
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

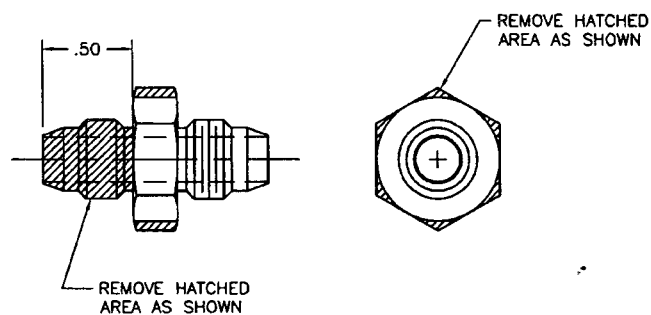
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



-003 REDUCER TEE



-005 FITTING

87106

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*Era Aviation, Inc.*

TITLE

REDUCER TEE ASSY

SIZE

C

DATE NO.

41232-200-004  
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REV.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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